



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-11
Job Sheet 173626



Part No: RBST1009-11

Job Qty: 10 ea

Part Name: Primary Seat



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/13/18	0.00	0.00	Start Up Machining-4		
110	CNC Lathe	10 pcs		3/14/18	0.00	2.50	MORI SL-154		
120	QC	10 pcs		3/14/18	0.00	0.00	QC2		
130	QC	10 pcs		3/14/18	0.00	0.00	QC8		
150	Outsource	10 pcs		3/14/18	0.00	0.00	Outsource12		
160	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging2		
170	QC	10 pcs		3/14/18	0.00	0.00	QC6		
180	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging3		
210	QC21-SA	10 Ea		3/14/18	0.00	0.00			

Part Op 110 - 1-Machine as per FOLIO FB 939, FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 120 - 1-Engrave P/N and "PRIMARY" using Marktronic engraver as per DWG.

150 - -Issue P/O to Groupe Altech; PO 039523 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

21 APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.500	AISI 4140 Quenched & Tempered Steel Round Bar 1.500" Dia.	1 ft (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.500	1	28	0

Part Specifications

Specifications could not be found.



Container No: S058768



Part: RBST1009-11

Job No: 173626

Serial No/Batch: S058768

Revision: 7

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

i9 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

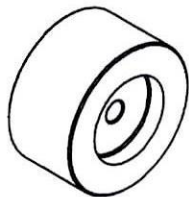
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

INSPECTION SHEET

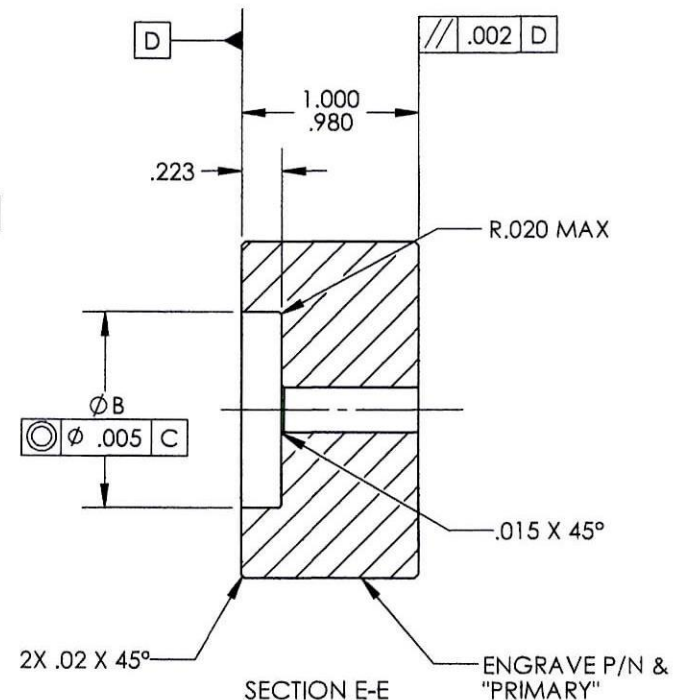
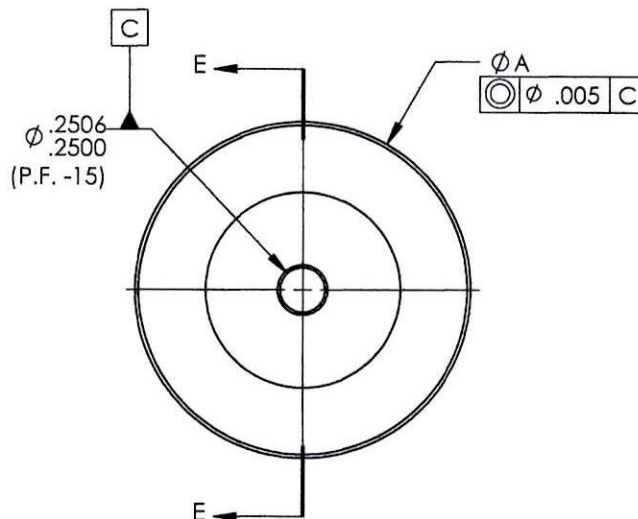
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	15-0033	-11 CH'D MATL FROM 4140 Q&T TO 4140/4142. ADDED HEAT TREAD RC 28-34. ADDED FINISH SPEC QMSI-6.2.2. B.O. REV D. CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T.	2/17/2015	DPD	SM



TOOL NUMBER	ØA +.000 -.030	ØB +.000 -.005
RBST1000	1.062	.470
RBST1001		
RBST1002		
RBST1003		
RBST1004		
RBST1005	1.312	.505
RBST1006		.560
RBST1007		.630
RBST1008	1.500	.705
RBST1009		.755
RBST1010		.830
RBST1011		.885
RBST1012	2.062	.940
RBST1013		1.090
RBST1014		1.140
RBST1015	2.437	1.220
RBST1016		1.156
RBST1017		1.385
RBST1018		1.660
RBST1019		
RBST1020		



NOTE:
BREAK ALL SHARP EDGES .015 - .030.

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO. SEE TABLE-11	REV 7
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .6°
SPEC QMSI-6.2.2. B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE TABLE
SCALE 1:1	DATE 1/4/2008 SHEET 7 OF 9

(-11)

PRIMARY SEAT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039523**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039523
PO Date: 4/6/18
Due Date: 4/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172908	RBE350A93-5300-00-3	Hex Head Cap Screw -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	4/17/18	2 pcs	0 pcs	2 pcs	\$29.1666/pcs	\$58.33
2	172889	PC250-1110	Bolt -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P16F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	4/17/18	4 pcs	0 pcs	4 pcs	\$29.1666/pcs	\$116.67
3	173902	RBE350A94-2704-00-01	Plate -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/17/18	16 pcs	0 pcs	16 pcs	\$2.14286/pcs	\$34.29

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	172216	RB T103147-101	Holding Fixture -Issue P/O to GROUPE ALTECH : -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, - Certificate of Conformity is required -Issue P/O to GROUPE ALTECH : -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, - Certificate of Conformity is required	Firmed	4/17/18	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00
5	173641	C10-OH	C-Series Remote Hook 10,000 lbs Lift Capacity	Firmed	4/17/18	1 pcs	0 pcs	1 pcs	\$270.00/pcs	\$270.00
6	173626	RBST1009-11	Primary Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/17/18	10 pcs	0 pcs	10 pcs	\$2.142857/pcs	\$21.43
7	173627	RBST1009-13	Secondary Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/17/18	10 pcs	0 pcs	10 pcs	\$2.142857/pcs	\$21.43
8	173628	RBST1009-15	Locating Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/17/18	20 pcs	0 pcs	20 pcs	\$2.14286/pcs	\$42.86
Grand Total:										\$685.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

DAS
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2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

008224- 3

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
12-Apr-2018		Curtis Anderson		PO039523				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
6	RBST1009-11 Rev.	RBST1009-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	10	10	0	0	0
7	RBST1009-13 Rev.	RBST1009-13 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	10	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.